

WELDING TECHNIQUE SHEET (Sample)

Title: _____ WTS No.: _____

Drawing No.: _____ Work Order: _____

Reference WPS(s): _____ Supporting PQR(s): _____

Process(es): _____ ☐ Manual ☐ Semi-Automatic ☐ Automatic/Machine

Material: _____ to _____

Base Metal Thickness: _____ Deposited Weld Metal Thickness: _____

Preparation: _____ Gas: _____ Flow Rate: _____

Backing / Back Gouge: _____ Current: _____ Polarity: _____

Welding Position(s): _____ Stringer or Weave Bead: _____

Preheat (Min.) °F: _____ Inter-pass (Max.) °F: _____

Pipe Diameter: _____ PWHT Required: ☐ Yes ☐ No

JOINT SKETCH

SPECIAL INSTRUCTIONS

Bead or Layer Sequence

Pass	Filler Metal	Size	Amps	Volts	Travel Speed	Heat Input (max.)

AUTHORIZED BY

DATE